

Work Order ID 142010

Tuesday, February 23, 2016 11:44:53 AM

142010

Page 1

Item ID: D3554-7 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Ball Stud
Start Date: 2/23/2016 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 3/11/2016 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: MLS Date: FEB 23 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3554	Rev A

100	PURCHASING	0.00							
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>31475</u> Purchase Part Number: BS104 Supplier: LS Technologies Certificate of conformity is required								

110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging	Ensure certificate of conformity is attached								

120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									

FEB 29 2016

Work Order ID 142010

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Item ID: D3554-7

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Ball Stud

Start Date: 2/23/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 3/11/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: St042 0.00***130***

Packaging

Memo

0.00

Packaging

10 ML5 1602-29

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

ML5 MAR 01 2016ML5 MAR 01 2016

Picklist Print

Tuesday, February 23, 2016 11:45:00 AM

Page 1

Work Order ID: 142010

142010

Parent Item: D3554-7

D3554-7

Parent Item Name: Ball Stud

Start Date: 2/23/2016

Required Date: 3/11/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 06-11-13 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
BS104		Purchased	No			110	Each	0.0000	1	10			
RS104													
BALL STUD													

**

OAS
6
9.00

FEB 29 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

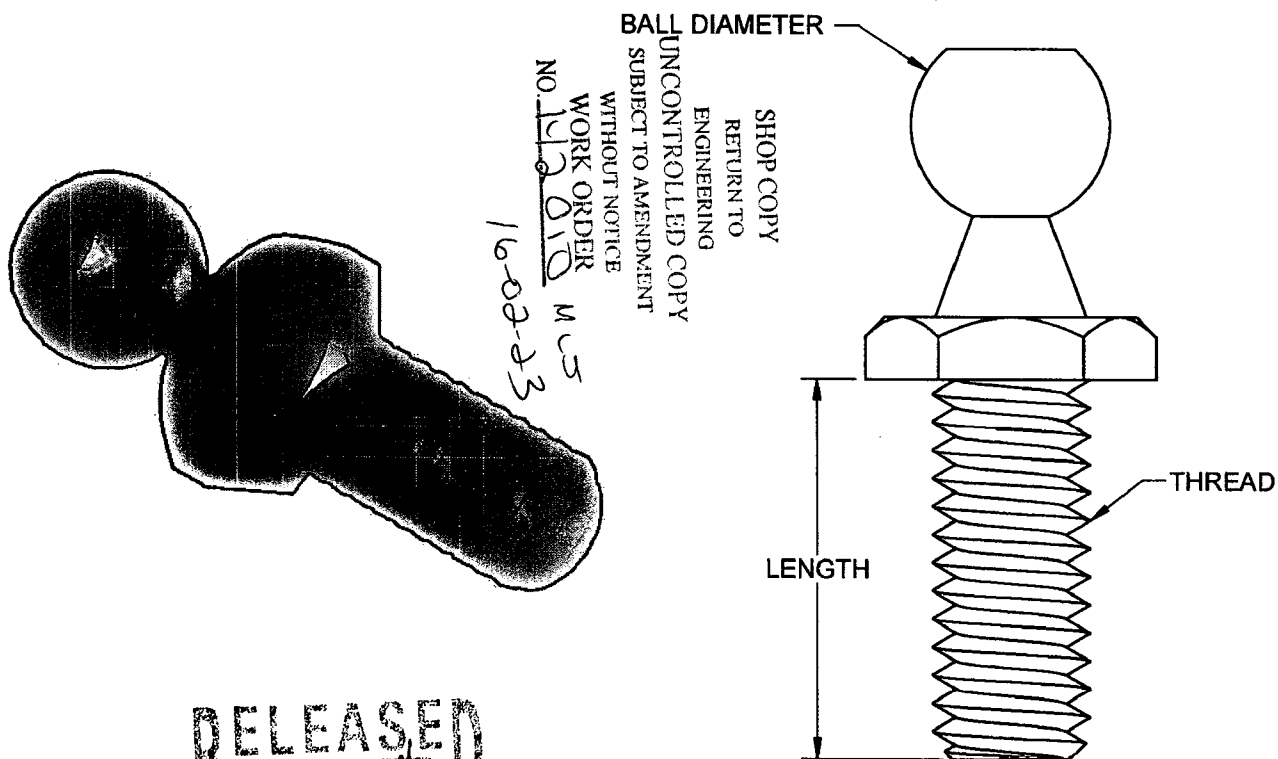
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
Misidentified ☐	☐ Past Due								



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3554	REV. A SHEET 1 OF 1
DATE 06.08.28		TITLE BALL STUD SCALE NTS	
REV A	DATE 06.08.28	DESCRIPTION NEW ISSUE	

SPECIFICATION CONTROL DRAWING



D3554-X BALL STUD

DART P/N	MATERIAL	BALL DIA	THREAD	LENGTH	POSSIBLE SUPPLIER
D3554-1	304 SS	10 mm	5/16-18 UNC	0.75"	McMASTER-CARR, P/N 9512K98
D3554-3	STEEL	10 mm	5/16-18 UNC	0.5"	McMASTER-CARR, P/N 9512K73
D3554-5	316 SS	10 mm	5/16-18 UNC	0.75"	McMASTER-CARR, P/N 9512K88
D3554-7	STEEL ZINC PLATED	10 mm	5/16-18 UNC	0.75"	LS TECHNOLOGIES, P/N BS104
D3554-9	STEEL ZINC PLATED	10 mm	5/16-18 UNC	1"	LS TECHNOLOGIES, P/N BS106

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LS Technologies Inc
314 Jessop Ave
Saskatoon, SK, S7N 1Y6
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

Feb 25, 2016

This is to certify that the parts listed below meets specifications as required by your order.

4 Units: D3552-7 B141993 Gas Spring

8 Units: D3552-11 B141994 Gas Spring

10 Units : BS104 Ball Stud as per DWG D3554-7 B142010

Country of Manufacture: Canada

Date of Manufacture : Feb 2016

This product is ROHS compliant.

Purchase Order # 31475

Invoice # 14455

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to be 'Nolan Fehr', written over a horizontal line.

Nolan Fehr
Manager

LS Technologies Inc
314 Jessop Ave
Saskatoon, SK S7N 1Y6

Ph: 306-683-5000 Fax: 306-683-6403

Packing Slip ..

P.O. No.	Date	Invoice #
31475	2/25/2016	14455

Bill to:
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship to:
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship	Via	FOB
2/25/2016	Fed-Ex	

Qty	Description
4	D3552-7 B141993 Gas Spring
8	D3552-11 B141994 Gas Spring
10	BS104 - D3554-7 B142010 10mm Ball Stud Zinc 5/16-18 Thd .75" Lg
Shipping Via FED EX Tracking # 775734899572	
10/2/29 SV	

Order checked by



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO31475**

Purchase Order Date 2/24/2016

PO Print Date 2/24/2016

Page Number 2 of 2

Order From :

LS TECHNOLOGIES INC.
314 JESSOP AVE
SASKATOON, SK S7N 1Y6
CA

VC-LST0001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 306 683 5000

Ship To Contact

Ship To Phone

Ship Via: FedEx Economy collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB EXW - (Ex Works)

3	BS104	BALL STUD	3/2/2016	10.00		\$1.55	\$15.50
			Yes	Each			

AS PER DWG D3554-7 REV. A
B142010

3/2/2016

Line Total: \$15.50

4	71401-45	PROCUREMENT QUALITY CLAUSES	3/2/2016	1.00		\$0.00	\$0.00
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Procurement Quality Clauses
A004 faa-pma/tso
A005 right of entry
A016 personnel qualification
A025 certification of conformance
A040 notification of quality escape
A043 retention of quality documents

No
3/2/2016

16/2/27
50

Line Total: \$0.00

PO Total: \$493.81

PO Instructions: Fedex Acc#151793240

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 2/24/2016